

Work Order ID 165808

Tuesday, August 29, 2017 3:09:26 PM

165808

Page 1

Item ID: D4038-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle, Fwd, RH

Start Date: 9/6/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/18/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89Date: ~~AUG 30 2017~~

Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4038

E

100

0.00

100

Bandsaw

Memo

Jeaspa Bandsaw

Cut Blank 7.125" long

0.19

0.10

1.57

110

110

HAAS I

HAAS CNC vertical machine #1

Memo

Mill as per Dwg & Folio FA880

Dwg Rev: Folio Rev: 

Deburr

DAS
49
9-89

17/09/01

DAS
49
9-89

17/09/15

Work Order ID 165808

Tuesday, August 29, 2017 3:09:26 PM

165808

Page 2

Item ID: D4038-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Angle, Fwd, RH
Start Date: 9/6/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 9/18/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				4	0		DAS 49 9-89 17/09/05
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				4	0		DAS 14 9-89 17/09/12
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.95				4	0		2017-09-13 JSL BEB

Work Order ID 165808

Tuesday, August 29, 2017 3:09:26 PM

165808

Page 3

Item ID: D4038-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Angle, Fwd, RH
Start Date: 9/6/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 9/18/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150	QC7								
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: 51069	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

4 **SEP 13 2017** **DAS 6 9-89** **17/9/19** **DAS 21 9-89** **SEP 14 2017**

Picklist Print

Tuesday, August 29, 2017 3:09:25 PM

Page 1

Work Order ID: 165808

165808

Parent Item: D4038-2

D4038-2

Parent Item Name: Angle, Fwd, RH

Start Date: 9/6/2017

Required Date: 9/18/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased			No	100	f	22.9940	0.7	2.947368			
M6061T6A4 000W 250									**				
6061T6 ANGLE 4.00 x 4.00 x .250													

Location

Loc Qty

Loc Code

MAT028

22.994

m118106

21.663

m128265

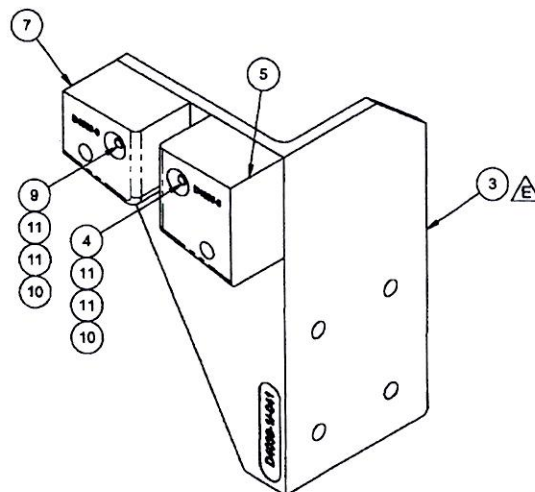
1.331

2.41

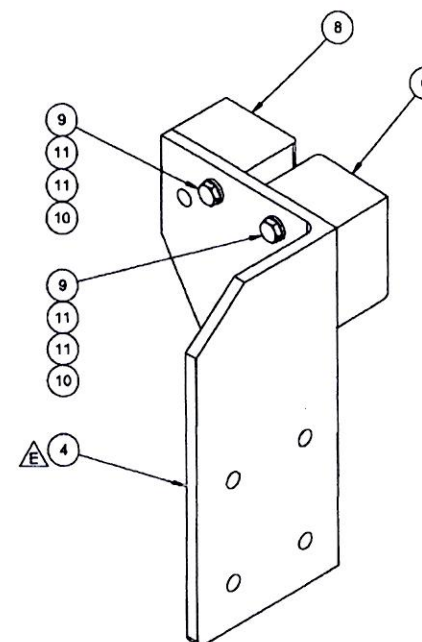
DAS
49
9-89

17/09/01

ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D4038-041	ANGLE ASSEMBLY, FWD, LH
2		X	D4038-042	ANGLE ASSEMBLY, FWD, RH
3	1		D4038-1	ANGLE, FWD, LH
4		1	D4038-2	ANGLE, FWD, RH
5	1		D4038-5	BLOCK
6		1	D4038-6	BLOCK
7	1		D4038-9	BLOCK
8		1	D4038-10	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER (AN960JD10)



D4038-041 ANGLE ASSEMBLY, FWD, LH



D4038-042 ANGLE ASSEMBLY, FWD, RH

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2011-04-21
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165808
AUG 30 2017

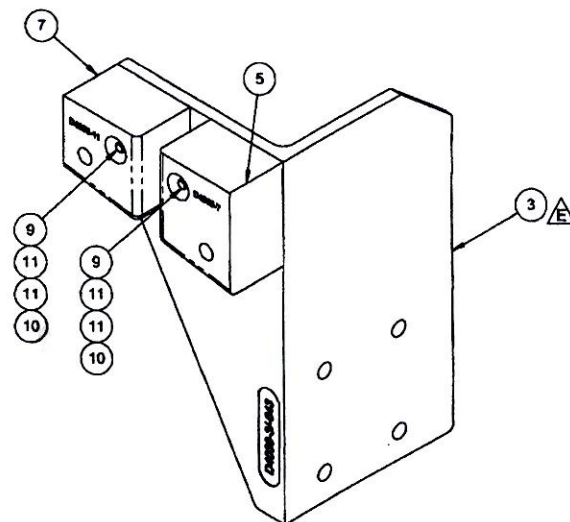
E	1.19 X 1.00 CHAMFER WAS R1.00. REF: NCR11-543.	MB	11.04.11
D	REVISED D4038-7/8/11-12 AS FOLLOWS: 1.87 WAS 1.73 (C7-9); 2.14 WAS 2.00 (C4-9); 2.13 WAS 2.00 (C7-10); 1.86 WAS 1.73 (C4-10); 1.52 WAS 1.38 (C7-13); 1.79 WAS 1.65 (C4-13); 1.77 WAS 1.65 (C7-14); 1.49 WAS 1.38 (C4-14). REASON: NCR11-456.	MB	11.03.03
C	REVISED D4038-3/4 AS FOLLOWS: 0.589 WAS 0.714 (B2-5, B4-6). D4038-043/044 ARE AFFECTED. REASON: NCR11-399.	MB	11.01.20
B	REVISED DIMENSIONS ALL SHEETS, ADD Ø0.316 HOLES IN -1/2/-3/4 PARTS, ADD RADII TO -1/2/-3/4 PARTS	HS	10.01.05
A	NEW ISSUE	HS	09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.04.11		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4038	REV. E
TITLE BRACKET	SCALE NTS
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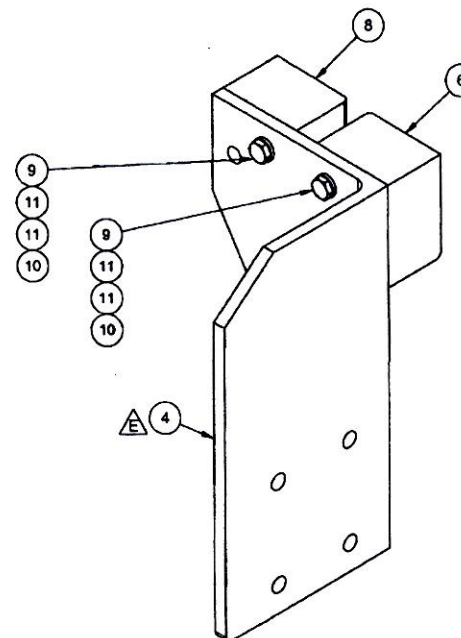
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041 - 1.75 lbs
-042 - 1.74 lbs

ITEM NO.	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X		D4038-043	ANGLE ASSEMBLY, AFT, LH
2		X	D4038-044	ANGLE ASSEMBLY, AFT, RH
3	1		D4038-3	ANGLE, AFT, LH
4		1	D4038-4	ANGLE, AFT, RH
5	1		D4038-7	BLOCK
6		1	D4038-8	BLOCK
7	1		D4038-11	BLOCK
8		1	D4038-12	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER (AN960JD10)



D4038-043 ANGLE ASSEMBLY, AFT, LH

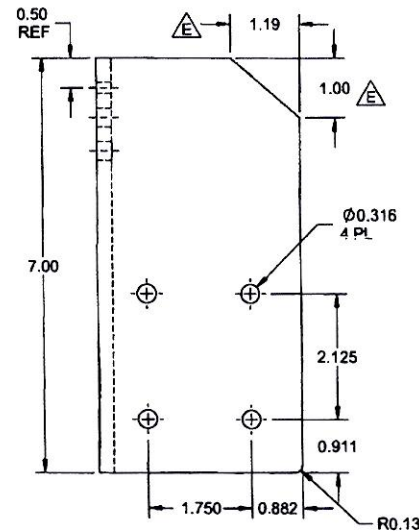
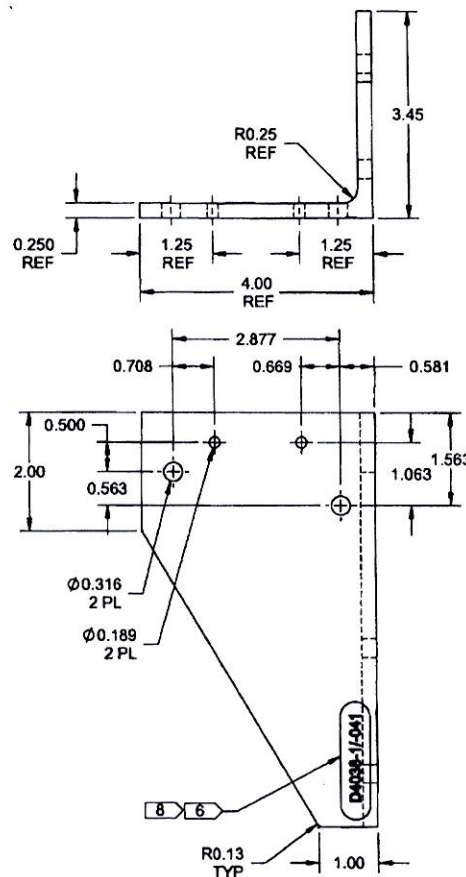


D4038-044 ANGLE ASSEMBLY, AFT, RH

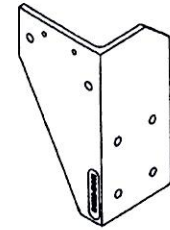
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: -043 - 1.96 lbs
-044 - 1.74 lbs

RELEASED
2011-04-21
JH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4038	REV. E
MFG. APPR.			SHEET 2 OF 14
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D4038-1 ANGLE, FWD, LH

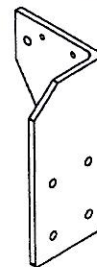
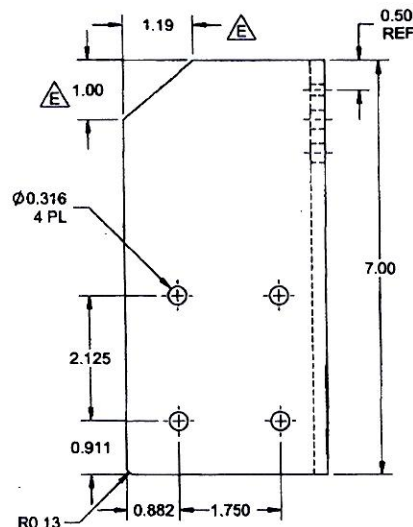
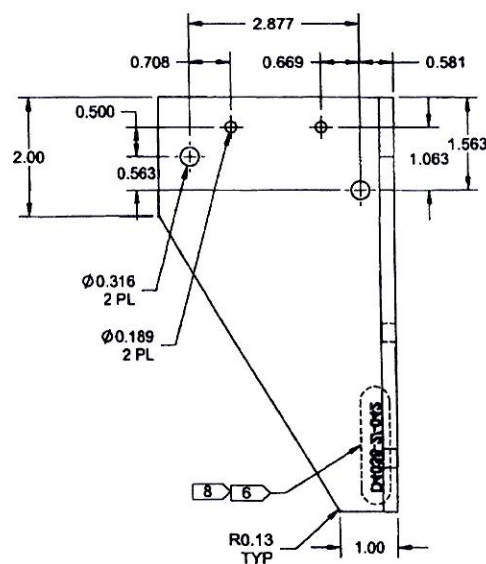
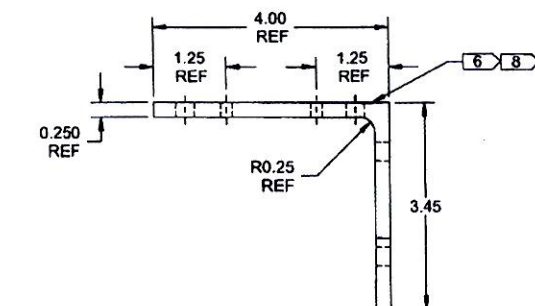


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2011-04-21

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.03 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

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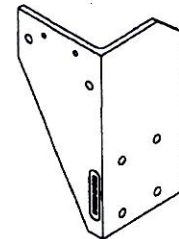
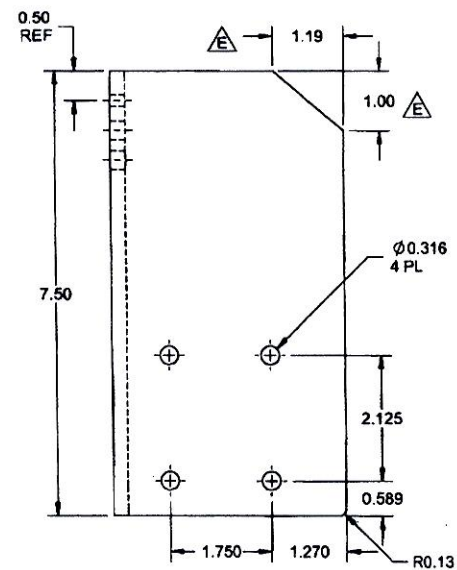
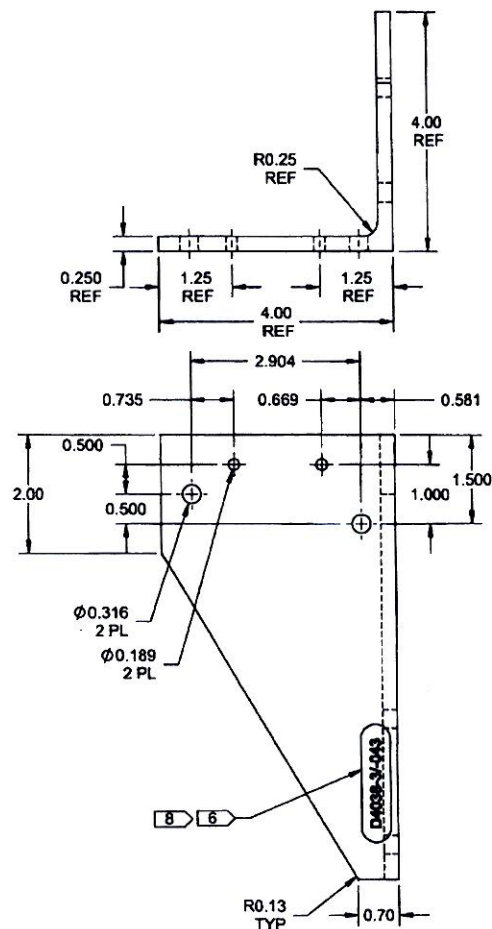
D4038-2 ANGLE, FWD, RH

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.03 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

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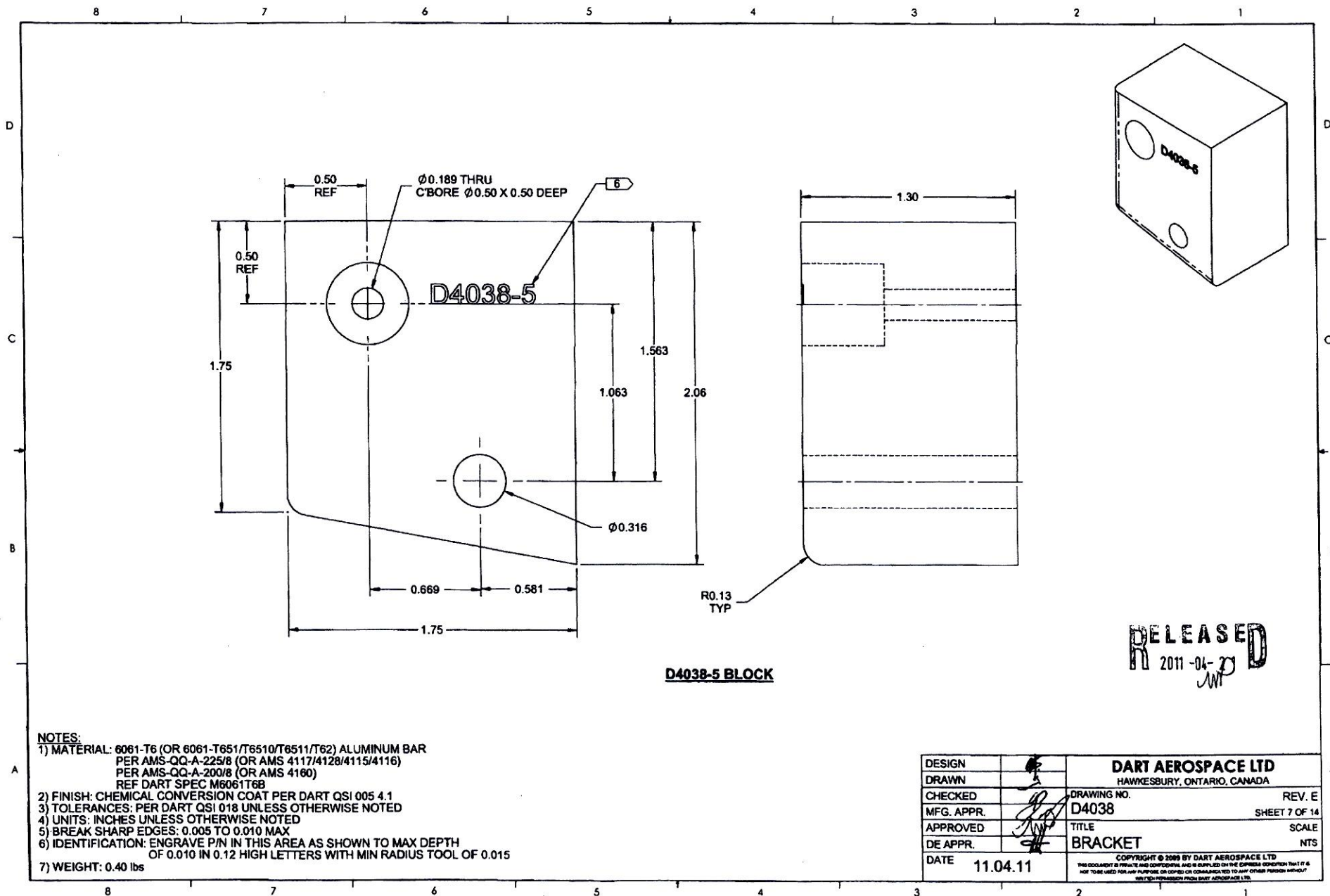
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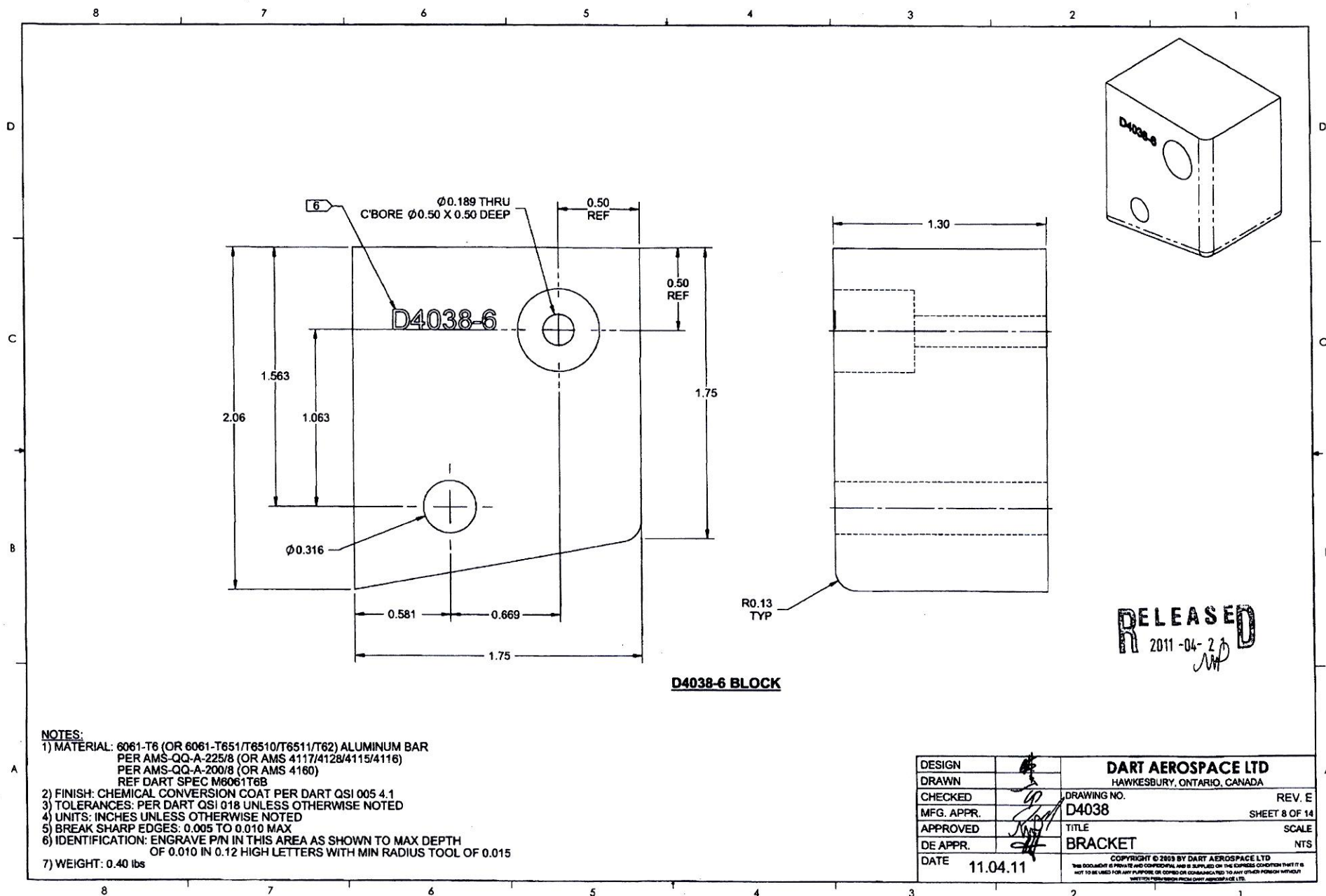
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.18 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

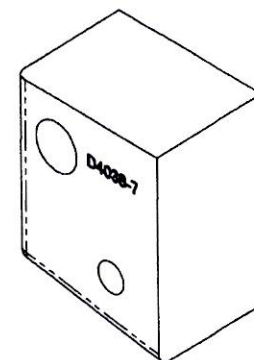
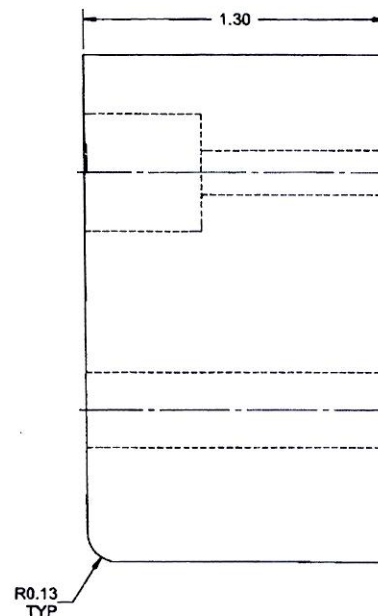
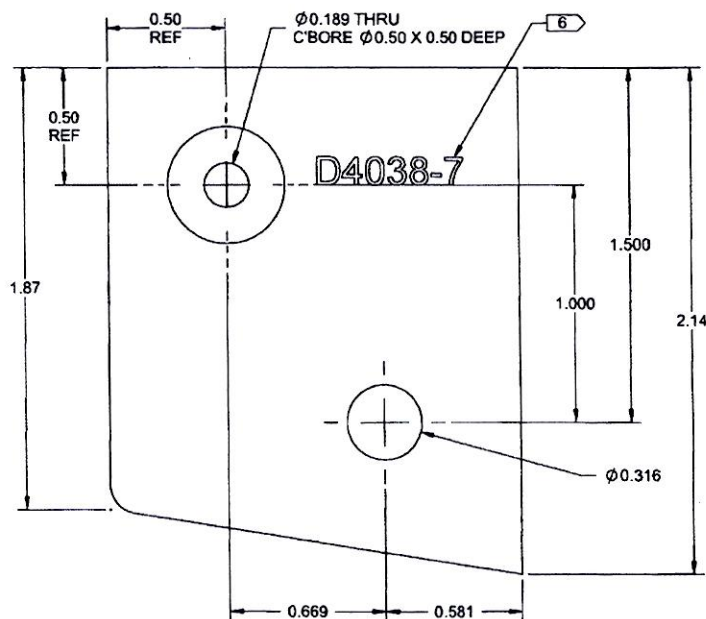
D4038-3 ANGLE, AFT. LH

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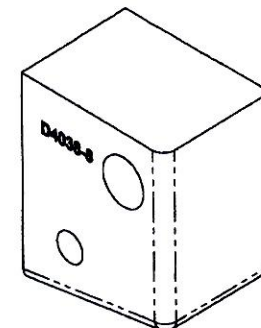
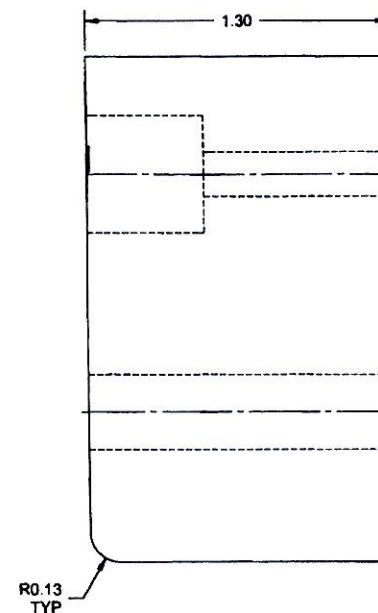
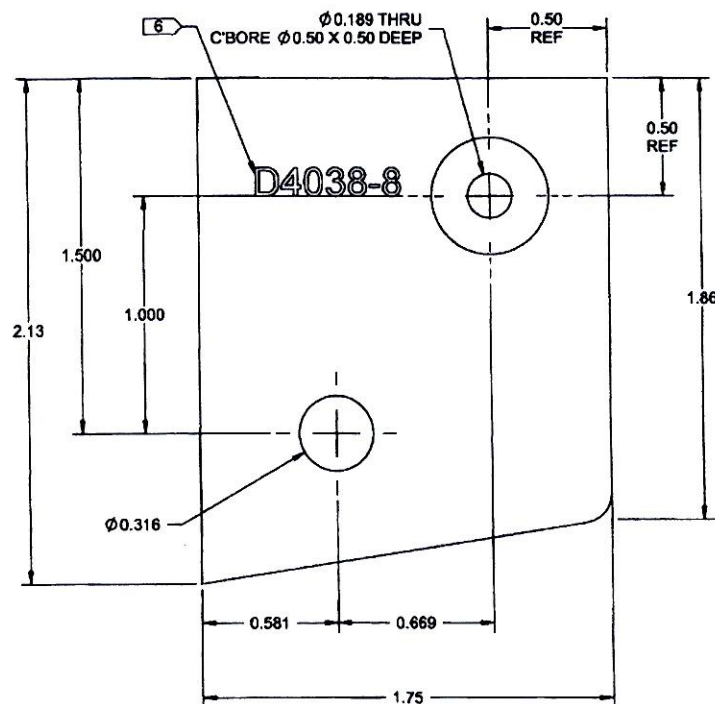
D4038-7 BLOCK

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4038	SHEET 9 OF 14
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MA



D4038-8 BLOCK

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

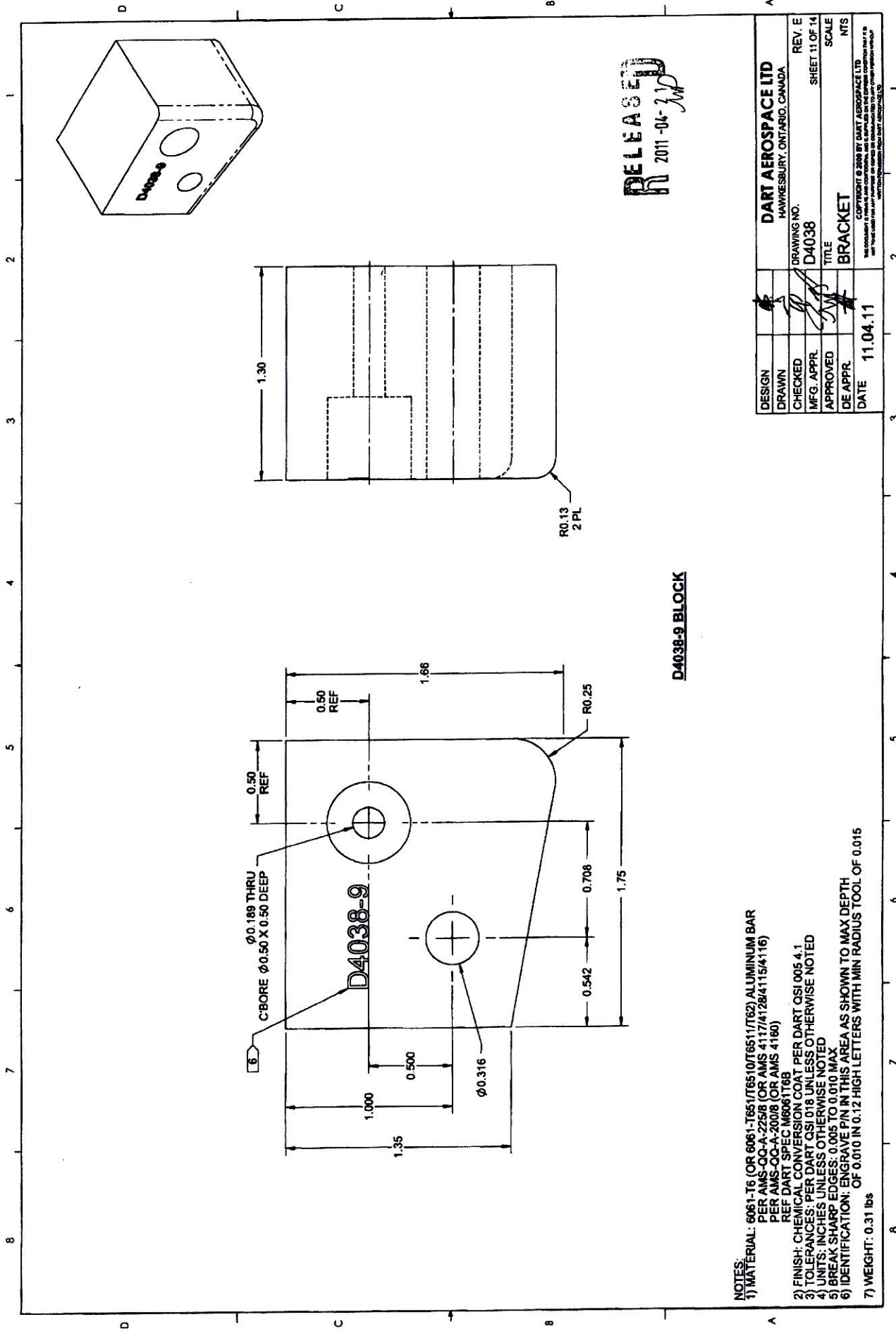
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015

7) WEIGHT: 0.42 lbs

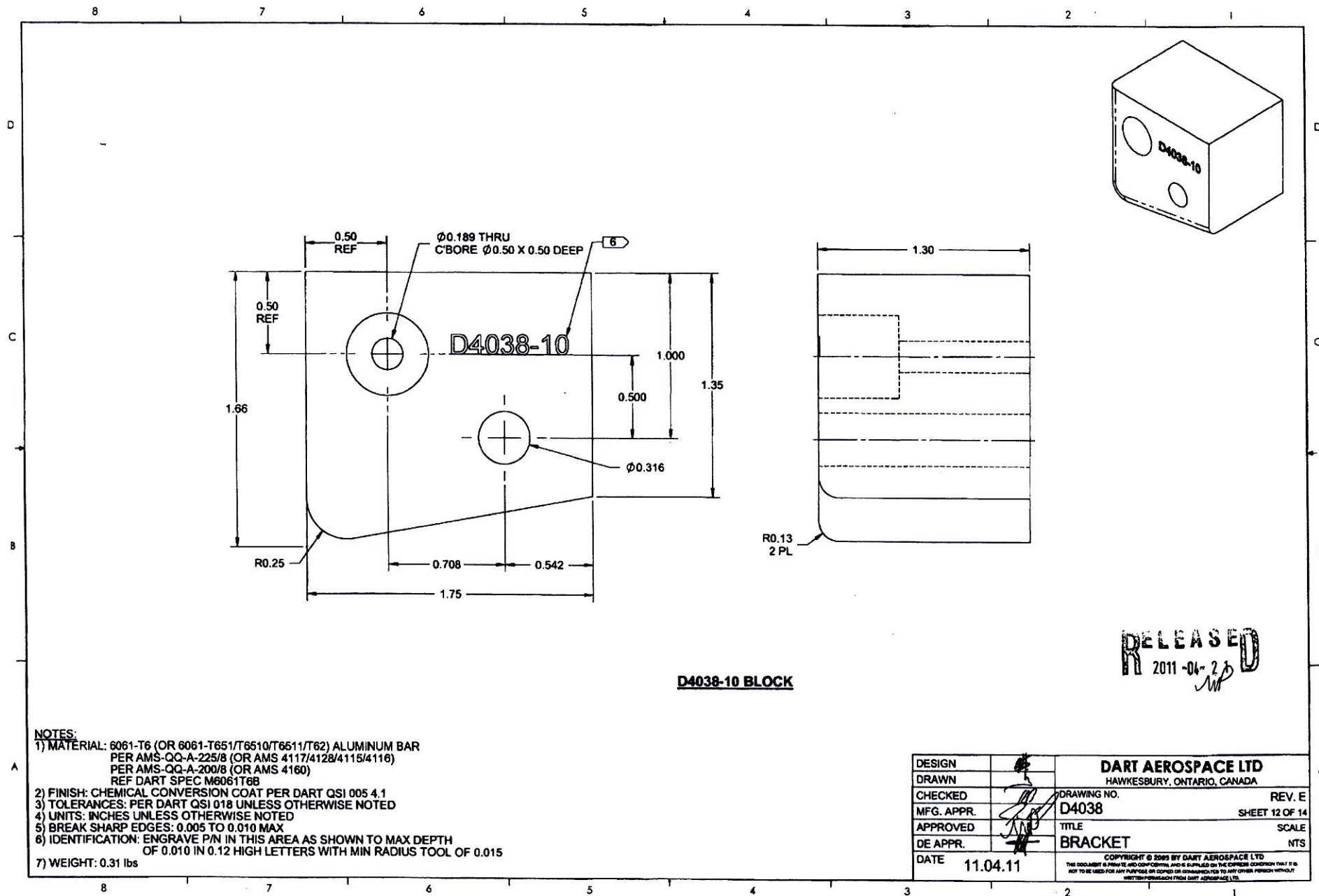
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2011-04-21
WMD

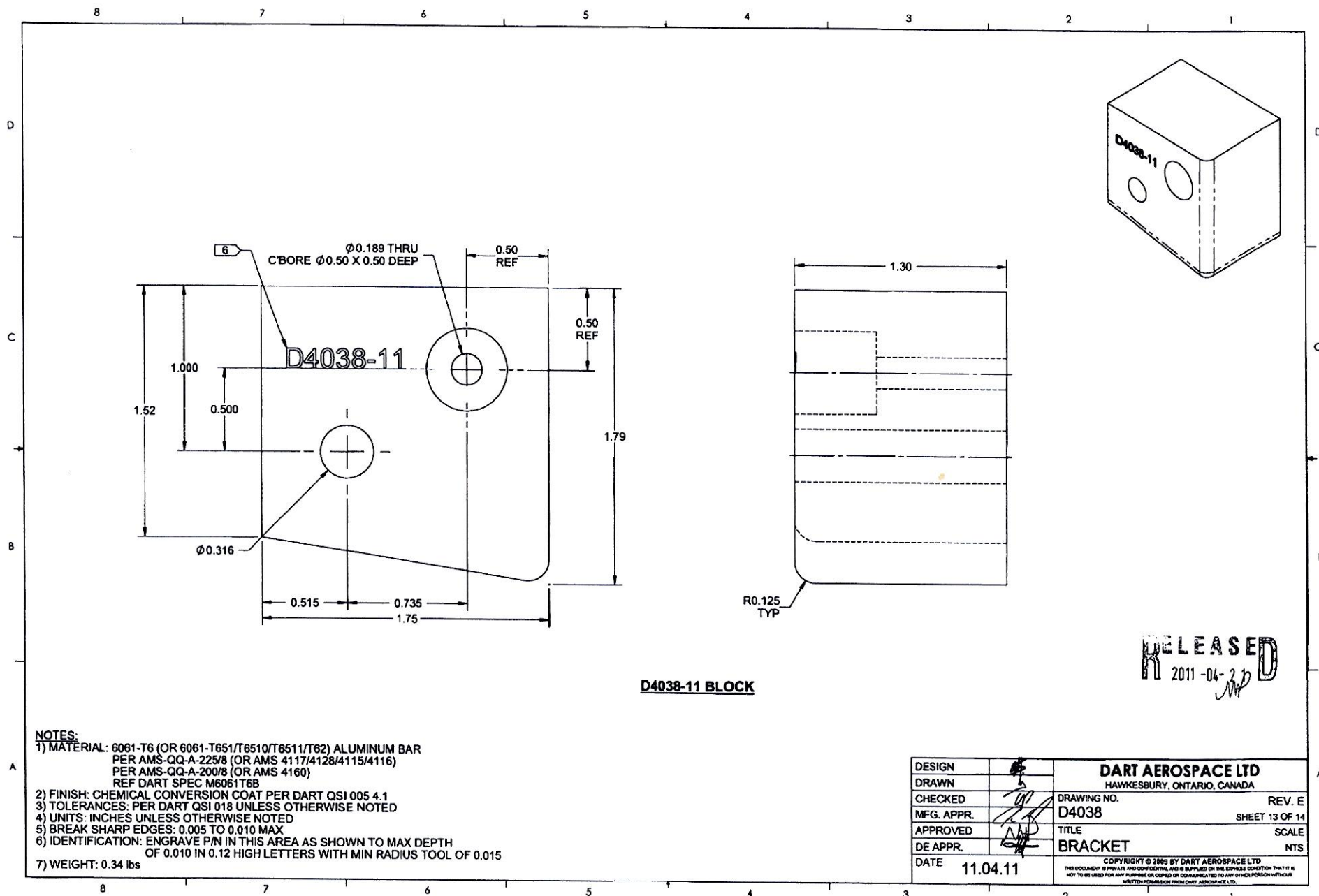
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4038	SHEET 10 OF 14
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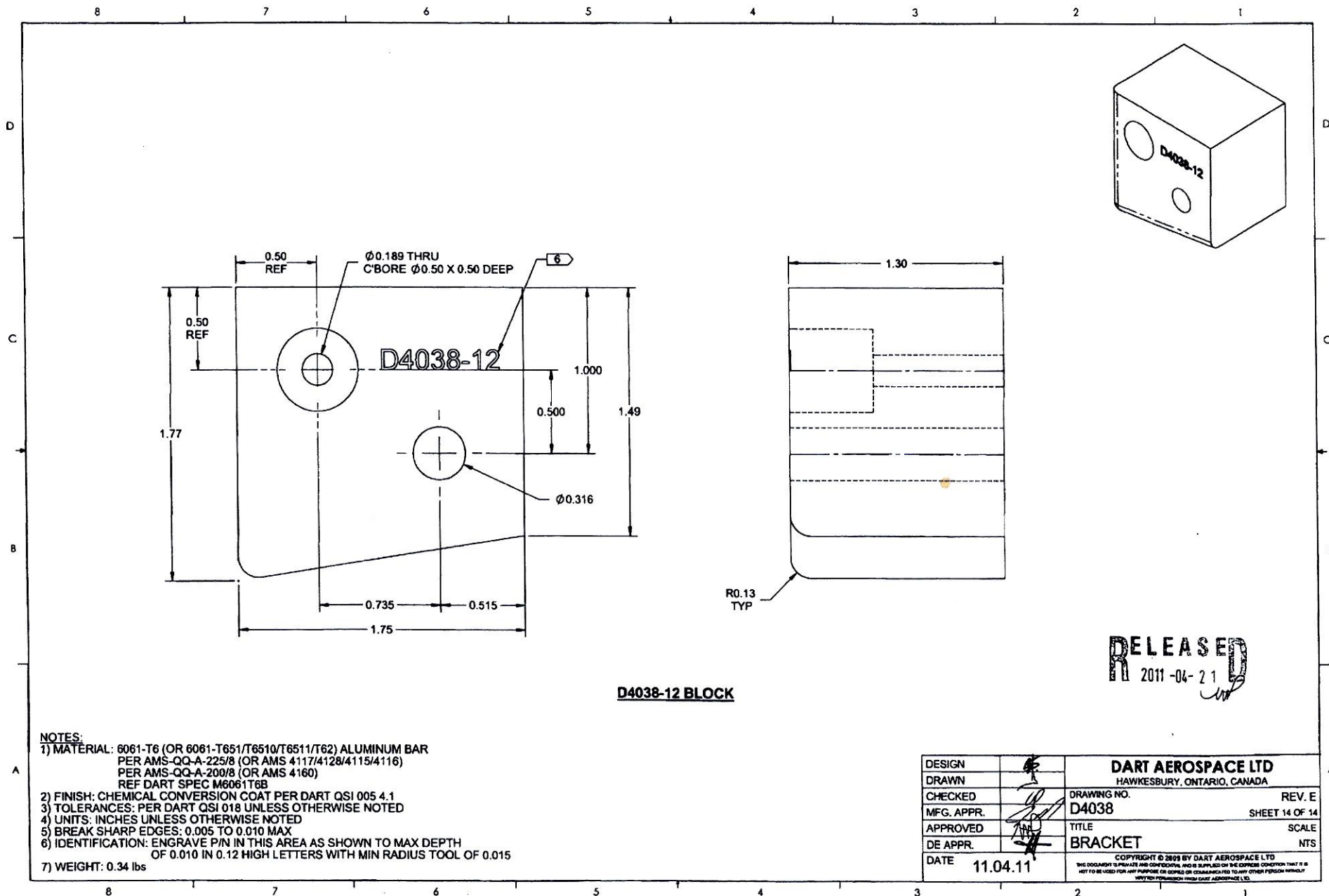


D4038-9 BLOCK

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
REF DART SPEC M6061T68
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
7) WEIGHT: 0.31 lbs







NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015

7) WEIGHT: 0.34 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4038	SHEET 14 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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DART AEROSPACE LTD		Work Order: 165808
Description: Angle, Fwd, RH		Part Number: D4038-2
Inspection Dwg: D4038	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	3.998	/		vern	mm L-05
3.45	+/-0.030	3.453	/		"	
R0.25	+/-0.030	0.28	/		RG	
0.250	+/-0.010	.247	/		vern	mm L-05
1.25	+/-0.030	1.240	/			
1.25	+/-0.030	1.254	/			
2.877	+/-0.010	2.877	/			
0.581	+/-0.010	0.581	/			
0.669	+/-0.010	0.669	/			
0.706	+/-0.010	0.702	/			
0.500	+/-0.010	0.498	/			
2.00	+/-0.030	2.00	/			
0.563	+/-0.010	0.563	/		Height	3100G
Ø0.316	+0.006/-0.001	0.316	/		vern	mm L-05
Ø0.189	+0.005/-0.001	0.189	/		"	
R0.13	+/-0.030	0.130	/		RG	
1.00	+/-0.030	1.00	/		vern	mm L-05
1.063	+/-0.010	1.061	/			
1.563	+/-0.010	1.560	/			
1.19	+/-0.030	1.19	/			
1.00	+/-0.030	1.00	/			
2.125	+/-0.010	2.125	/			
0.911	+/-0.010	0.906	/			
R0.13	+/-0.030	.13	/		RG	
0.882	+/-0.010	0.878	/		vern	mm L-05
1.750	+/-0.010	1.747	/			
7.00	+/-0.030	7.00	/			
0.50	+/-0.030	0.496	/			

Measured by: mml	Audited by: 14 9-89	Preliminary Approval:
Date: 17/09/05	Date: 17/09/12	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.04.05	Dwg Rev updated	KJ	
C	11.06.21	Dwg Rev updated	KJ	